

Date: Thursday, 10/18/2007 8:03:17 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT WEB
Job Number : 35211	
Estimate Number : 10791	
P.O. Number : <i>N/A</i>	Part Number : D3282041
This Issue : 10/18/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3282 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34794	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/31/2007 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:B 05.09.23 Procedure change KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2792130	EXTRUSION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1 D2792-130

Extrusion

B33518

DP 7-11-20

(12)

Identify as D3282-1

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

DP 7-11-20

(12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

SN/J.L

07/12/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD/J.L

07/12/11

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F 07/12/11

(12)

J/O: _____

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:03:17 AM

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Process Sheet

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Drawing Name: FLOAT WEB

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Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JO 7-12-12

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 7-12-13

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

34264(16) (8) 35230

SL 7-12-13

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total : 684.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD47

Rivet

104936

SL 7-12-13

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web

A/RN/ALPS-3

104929

SL 7-12-13

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SL 7-12-13 (X12)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

(12)

SL 7-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 07/12/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:03:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 35211

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12
10/12/14

Job Completion



U 10/12/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 35211
Description: Float Web		Part Number: D3282-041
Inspection Dwg: D3282 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

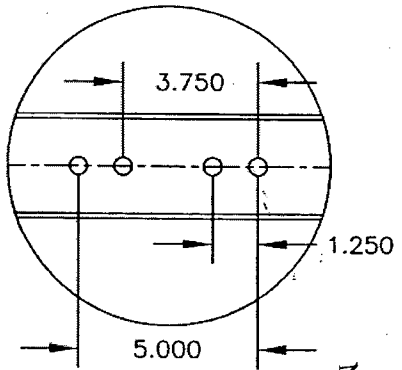
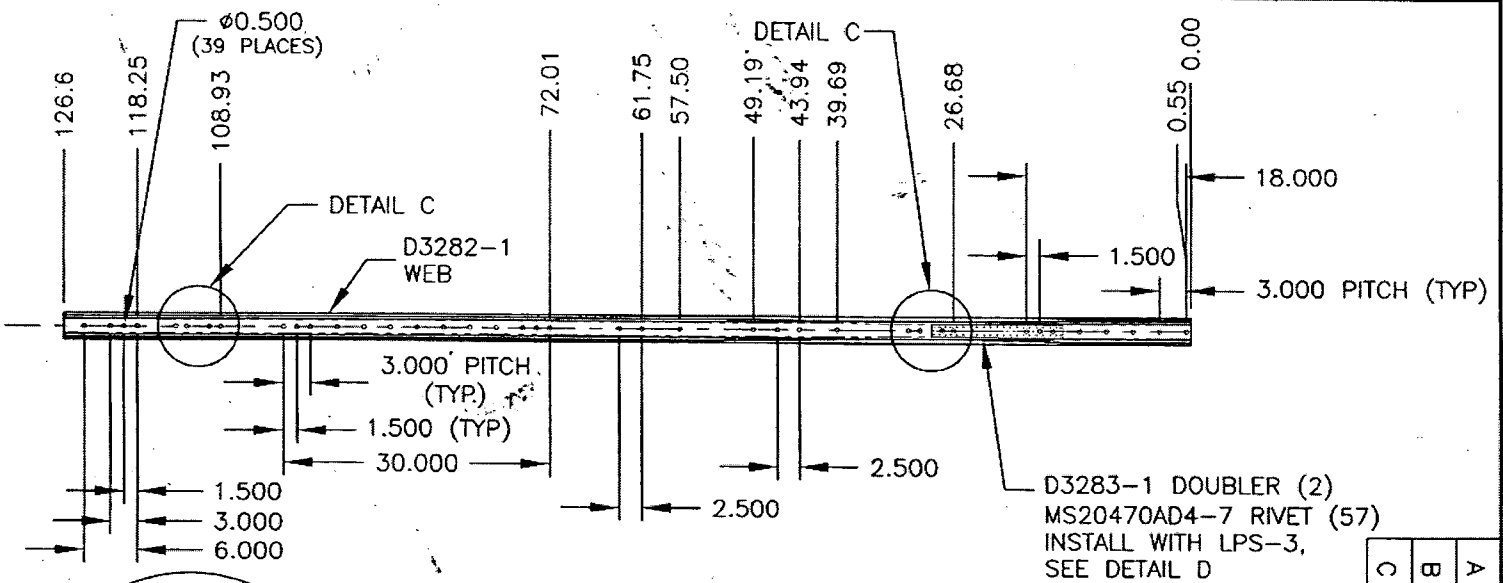
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.6	/			
1.500	+/-0.010	1.500	/			
3.000	+/-0.010	3.000	/			
6.000	+/-0.010	6.000	/			
1.250	+/-0.010	1.250	/			
30.000	+/-0.010	30.000	/			
1.500	+/-0.010	1.500	/			
72.01	+/-0.030	72.01	/			
61.75	+/-0.030	61.75	/			
57.50	+/-0.030	57.50	/			
49.19	+/-0.030	49.19	/			
43.94	+/-0.030	43.94	/			
39.69	+/-0.030	39.69	/			
26.68	+/-0.030	26.68	/			
0.55	+/-0.030	.550	/			
1.970	+/-0.010	1.980	/			
2.38	+/-0.030	2.376	/			
0.05	+/-0.030	.046	/			

Measured by: SN	Audited by: L.F	Prototype Approval:	N/A
Date: 01.12.06	Date: 07/12/07	Date:	N/A

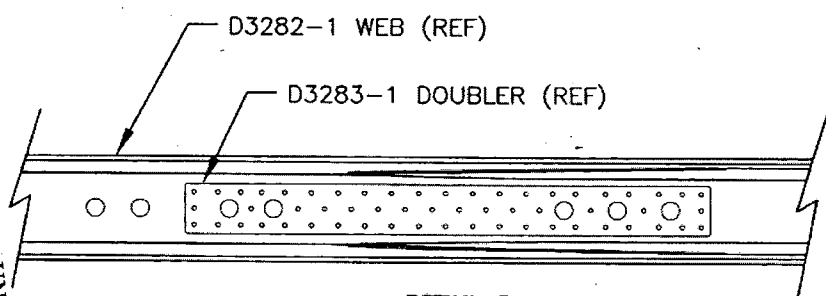
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CP	CP	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
<i>[Signature]</i>	<i>[Signature]</i>	D3282	SHEET 1 OF 2	
DATE		TITLE	SCALE	
05.08.09		FLOAT WEB, 206L/407	1:20	
A	04.05.05	NEW ISSUE		
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS		
C	05.08.09	REMOVE D3390-1, NOW MACHINED		



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35211

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

RELEASED
05.09.12

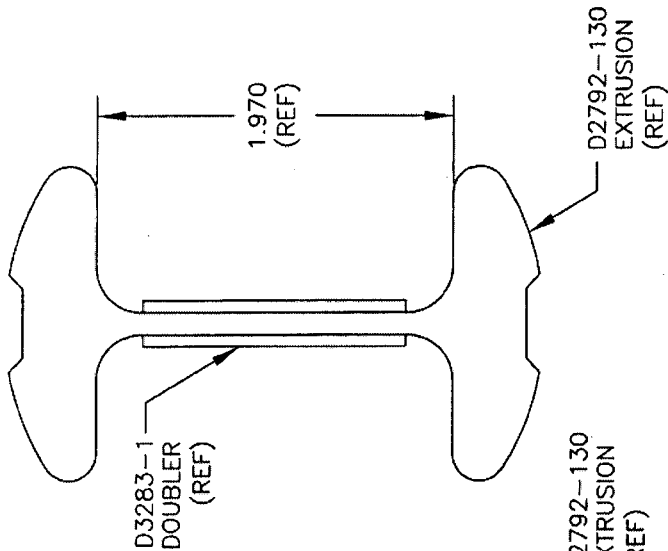


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3282	REV. C SHEET 2 OF 2
DATE 05.08.09	TITLE FLOAT WEB, 206L/407		SCALE 1:20

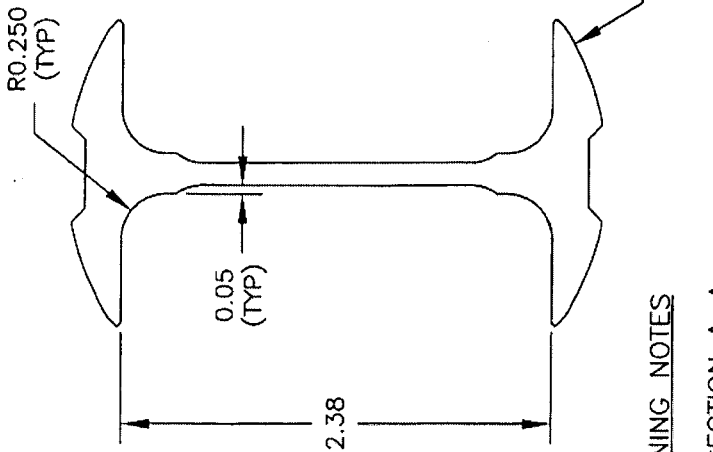
RELEASED

05.09.12

SECTION B-B



SECTION A-A



D3282-1 MACHINING NOTES

1 UNIFORM SECTION A-A

2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B

3 UNIFORM SECTION B-B

4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE

5 UNIFORM SECTION A-A
R1.00 BETWEEN SECTIONS

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WORK ORDER
NO. 35211

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